Work Orde Friday, August 2						Page !									
Item ID: Revision ID: Item Name:	D2942 Replacement	Window for	-025	***************************************	Accept		*N900	040	100)*	Setup	Start Stop	*N:	S1 ² S2 ²	<u></u> k k
Start Date: Required Date: Reference:	8/23/2013 8/23/2013	Start Qt Req'd Q	-	*4* *4*			Cust Item I Customer:	D:							
Approvals:	Process Pla	an:	p.	Date: 13-08-3	Tooling SPC (Y/			ate:			Run	Start Stop	*N *N	R1 ³	*
Sequence ID/ Work Center II	 D	Operatio Descripti			Set U Run	p/ Hours	Tool ID	Tool #	Plan Code	Accept	t Re Qt		Reject Number	Insp. Stamp	р
Draw Nbr	Rev	vision Nbr	•												
D2942	Rev	v C	 I									•			
*100 *100* Small Fab Small Fab		Small Fab	Memo Assemble a	s per Dwg D2942 clean &	0.00 0.00 wrap in plastic	:				4		SAC)(3	-08-	<u>ديه</u>
*110 *110* QC Quality Control		QC5- Inspe	ct part comp . Memo	leteness to step on W/O	0.00	DAS 27 989	3		-	4		. <u> </u>			
120		Identify as	ner dwg & Si	tock Location (3x) ST	213 0.00										

120 Packaging

Memo (1x) PPP 98927 0.00

4x M. W. 13-08-23

Packaging

DQA:		_ Date:			. WORK ORDER NON	TDART						
QA Closed:		Date:			WORK ORDER NON-	-((JINFOI	RIVIANCE / U		Work Order u	pdate only	AEROSPACE
Work Orde	or.				DISPOSITION				AGAINST [DEPARTMENT	/PROCESS	
WOLK Olde					Rework			Skid-tube	Crosstube	_	Water Jet	Engineering
Part N	No.				Scrap		,	Machining	Small Fab	Pro	od. Eng. Coor.	Quality
					Use-as-is			noforming	Finishing		re/Packaging	Other
NCR f	No				Suspected Unapproved			Large Fab	Composite		Supplier	
Root		1	T	Desc	I		nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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	Crushing			\vdash	Cut Too Short	_	Mislabe		-	Power Loss,	_	Other
	⊢	at on Strip in	Tubo		Drawing	\vdash	Misread		Ļ	rower Loss,	-2418¢	Totalei
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		wist in Tul		-	Fit/Function		i	Sequence				
				ı	1,	1	, ~ ~ . ~					

Work Order ID 105893 Page 2 Friday, August 23, 2013 11:21:19 AM Accept Item ID: D2942 *N900040100* Setup Start Revision ID: Stop Item Name: Replacement Window for -025 *4* Start Date: 8/23/2013 Start Qty: 4.00 **Cust Item ID:** Required Date: 8/23/2013 Req'd Qty: 4.00 **Customer:** Reference: Run Start Process Plan: Date: _____ **Tooling:** Approvals: Date:_ Stop SPC (Y/N): Date: Date: Operation Tool # Plan Reject Sequence ID/ Set Up/ Tool ID Accept Reject Insp. Work Center 1D Description Run Hours Code Qty Qty Number Stamp 130 QC21- Final Inspection - Work Order Release 0.00 MUS 13-08-26 *130* QC 0.00 Memo

20

Quality Control

DQA:		Date:										™DART
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE	W	ork Order up	odate only	AEROSPACE
					DISPOSITION			AGAINS	r DE	PARTMENT	/PROCESS	
Work Orde	er:				Davioris	1		Chief turbo Concetub	\Box	7	Water Jet	
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raiti				—	Use-as-is			noforming Finishing	\vdash	=	re/Packaging	Other
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						j		24.80 . 42	· L	J		
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	Cracks	i			Broken/Damage/Defect		Hardwa	ire	L	Part Incorre	ct	Temperature/Cure
	Crimp	/Kink/Ripple	e/Wave	L	Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crushi	ng			Countersink		Misalig	ned/off center	L	Positioned V	Vrong	_
	Heat 1	reat			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	inspec	tion Strip in	Tube		Drawing		Misread	t				
	Marks	/Chatter			Drill Holes		Off-set					
	Turnir	g Sequence	!		Finish		Out of	Calibration				
_	Wave,	Twist in Tu	be		Fit/Function		Out of s	Sequence				

Friday, August 23, 2013 11:21:23 AM

D2942

Parent Item Name: Replacement Window for -025

Start Date: 8/23/2013

Required Date: 8/23/2013

Page 1

Start Qty: 4.00

Required Qty: 4.00

D01.06.05New processEC

E Thermoform in house

07 03 07 DI

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2126		Manufactured	No			100	f	507.8140	5.625	22.5			 -
D2126									** 	SAO	13	-082	2 <u>3</u> _
				Location		Loc (<u>Oty</u>	Loc Code					
				ST405	102729 -89058	4	.814 67.5 .314			22,5			
D2956		Manufactured	No		0,000	100	Each	11.0000	1	4			
D2956 Window Frame									**	SA) <i>ji</i>	3-08	-2B
				Location		Loc	<u>Oty</u>	Loc Code					
				ST213		•	11		_				
					66565 90225	•	1		_				
					94806		5		_	4			
					97324		4		_				
02958		Manufactured	No			100	Each	6.0000	l	4			
D2958									**	SAD	13	<u>-88-</u>	}3_
				Location	i	Loc	<u>Oty</u>	Loc Code					
				ST208	86092		6 1			(
					91597 97168)		2 3		_	(a)			

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Part N	ο.				Scrap			Machining Small Fal	b	Pro	d. Eng. Coor.	Quality		
					Use-as-is		Therr	noforming Finishin	g[_	Rec/Stor	re/Packaging	Other		
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Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
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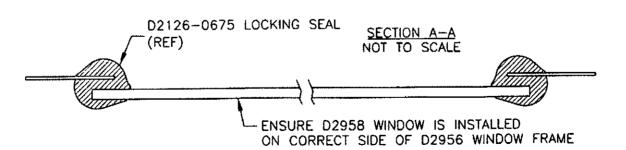
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DESIG	n G	DRAWN BY	DART AEROSPA HAWKESBURY, ONTARK	
CHEC	KED	APPROVED/	DRAWING NO. D2942	REV. C SHEET 1 OF 1
DATE	<u> </u>	1	TITLE	SCALE
01.0	05.31		REPLACEMENT WINDOW	1:5
Α		00.01.20	NEW ISSUE	
В		00.02.23	CHANGED FROM RIVET TO SEALED ON EDGE ONLY	O SCREW; NOW (NCR 407)
C		01.05.31	WINDOW NOW INSTALLED	WITH SEAL

RELEASED

P 13/1/23 D2126-0675 LOCKING SEAL D2956 WINDOW FRAME 105893 10589 D2958 WINDOW UNDER FRAME 1.10 (TYP) DIST. FROM FRAME EDGE TO WINDOW



NOTES

1) ALL DIMENSIONS ARE IN INCHES

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DQA: Date:						- ····································									
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	_					Rework]		Skid-tube	Crosstube	7	Water Jet	Engineering		
Part N	No.					Scrap	1	•	Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
	_					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other		
NCR N	No					Suspected Unapproved	1		Large Fab	Composite		Supplier			
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Root					Desci	ription of work order update	1	Initial	A	ction	Sign &		·		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Des	cription	Date	Verification	QC Inspector		
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